



STANDARD OPERATING PROCEDURE

2-Sided Bumper Repair

Rigid Plastic
BMC, PC, SMC, Fiberglass

Semi-Rigid Plastic
ABS, PP, PU, RIM, TPO, TPU

Inspect	1	Inspect & assess bumper damage (e.g. crack, gouge, rip, puncture, etc.).	
	2	Verify bumper resin material. See SOP 022. Then check Transtar TDS for suitable substrates with all repair & refinish materials.	
Clean	3	Wash front & back of part with warm water & soap (silicone & oil free). Assure all silicones are removed. Dry part completely.	
	4	Clean front & back thoroughly with waterborne degreaser, Aqua SCAT 2 #1391/4. Do not use solvent cleaners on plastic.	
Grind	5	Grind front-side damage area with 50-80 grit disk. "Dish out" & taper (V-shape) damage area slightly.	
	6	Grind backside of damage area to remove defects with 50-80 grit disc. Rough the surface around damage where adhesive will be applied.	
Sand	7	Sand front damage area with 80 grit & DA.	
	8	Featheredge front with 180 grit to create smooth transition.	
Drill	9	For cracks in bumper, drill 1/8" - 1/4" hole at each end of crack to prevent further spreading.	
Clean	10	Blow off part. With a lint-free cloth, clean the repair area using Aqua SCAT 2 #1391/4. Dry thoroughly.	
	11	Blow off part again to remove lint, dust, etc.	
Prep	12	Apply light coat of Transtar Mul-Tie Adhesion Promoter #1031/3 to front & back of part where adhesive will be applied. Allow to flash for 15 minutes.	12 Apply light coat of Transtar Mul-Tie Adhesion Promoter #1031/3 or Plasto-Mend TPO Adhesion Promoter #1021/1023-F to front & back of part where adhesive will be applied. Allow to flash for 15 minutes.
	13	On front-side, align panel surfaces using aluminum repair tape or clamps.	
	14	Cut a piece of plastic repair reinforcing tape to length of damage area plus 1" beyond repair area.	
	15	Insert cartridge in gun. Equalize cartridge by dispensing material until both components flow equally. Then attach nozzle. Gun out nozzle length of material to ensure proper mixing. Refer to TDS.	
Back	16	On backside, on & around the damage area, apply Plasto-Mend #1478 adhesive. On semi-rigid plastic, use #1478 adhesive as rigid backing. Spread a thin, even coat to repair area.	
	17	Align & press section of plastic repair reinforcing repair tape (from Step above) into Plasto-Mend adhesive.	
	18	Apply 2nd coat of Plasto-Mend #1478 adhesive. Spread until repair tape is covered. Let cure 20 minutes.	
Clean Sand	19	On front-side, sand with 80 grit on palm sander to remove excess repair material from backside.	
Clean	20	Blow off part. Clean with Aqua SCAT 2 #1391/4. Blow off part again to remove dust, lint, etc.	
Front	21	Apply Plasto-Mend #1478 adhesive to front-side repair area. Spread adhesive evenly onto surrounding area 1" beyond damage area. Let cure 20 minutes.	21 Apply Universal Plastic Repair #1468-G adhesive to front-side repair area. Spread adhesive evenly onto surrounding area 1" beyond damage area. Let cure 20 minutes.
	Sand	22	Block sand front-side with 150 grit to smooth out adhesive.
23		Finish sanding with 220 grit. Featheredge repair into existing finish.	
Clean	24	Blow off part. Clean with Aqua SCAT 2 #1391/4. Blow off again to remove lint.	
Prime	25	Tack off. Apply Transtar primer suitable for plastic substrate. See SOP 021/2 for detail. Apply primer following TDS recommendations.	
Paint	26	For finishing repaired plastic, see Transtar SOP 252.	

SUGGESTED MATERIALS FOR JOB

- Soap & water • Lint-free Towels • Lint-free Towels • Transtar Waterborne degreaser, #1394 • Grinding disc • Drill & bits
- Transtar Adhesion Promoter, Mul-Tie #1031/Plasto-Mend TPO #1021 • Transtar Plasto-Mend Plastic Repair Rigid #1478/Universal #1468-G
- Transtar Dual-Mix Side-Load Gun #4440 • Adhesive Spreader • Plastic Repair Reinforcing Repair Tape • Aluminum Tape
- Sandpaper – various grits • Sanding blocks • Palm Sander • Tack rags • Transtar Plastic Flex Primer

* Always refer to Transtar Technical Data Sheet (TDS) for specific product application, suitable substrates & other product information.